

Date:
User:Tuesday, 19/08/2008 4:07:23 PM
Julie Lecocq

Process Sheet

DALMAR

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : 90 DEGREE COVER PLATE

Job Number : 41511-2

Estimate Number : 13405

P.O. Number :

Part Number : PB674300169

This Issue : 19/08/2008 S.O. No. :

Drawing Number : B6743001 PAGE25

Prsht Rev. : NC

Project Number : N/A

First Issue : / / Type : SMALL / MED FAB

Drawing Revision : B1

Previous Run : 40069

Material :

Due Date : 18/09/2008

Qty: 10 Um: Ea

Written By :

Checked & Approved By : JUD 08.8.20

Comment : Est Rev:A 08-06-20 new issue DD verified by:ec

Additional Product

Job Number:



SCRAP

Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S032

6061-T6 Sheet 0.032"

Comment: Qty.: 1.4234 sf(s)/Unit Total: 42.7014 sf(s) 18147
6061-T6 Sheet 0.032" 18 8-9-8

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg B67-43001

Dwg Rev: B1

Prog Rev: B1

18 8-9-8

****grain direction along 9.144" ****

2-Deburr if necessary

18 8-9-8

30

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

18 8-9-8

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S 02/02/09 136 counter

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg B67-43001

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-69 PAR #: 09-011 Fault Category: Eng / Design NCR: Yes No DQA: D Date: 05/02/12
 Resolution: _____ Disposition: _____ QA: N/C Closed: 12 Date: 09/02/12

NCR: <u>41511-2</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-02-11	5.0	PART WILL NOT FIT UPON ASSY (REF B45076) 10 PARTS. R-C: PART REQUIRE REDESIGN.	<u>↓</u> 09/02/11	SCRAP & DESTROY QTY. 10 ENG. TO ISSUE NEW DWG. <u>PAR-09-011</u>	SAD 09-02-12	<u>109-02-12</u>	<u>09/02/11</u>	<u>S</u> 09/02/11

NOTE: Date & initial all entries

Process Sheet

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Drawing Name: 90 DEGREE COVER PLATE

Job Number: 41511

Part Number: PB674300169

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
Weld assembly as per dwg B67-43001

8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
1- grind weld flush

9.0	QC10	VISUAL INSPECTION OF GROUND WELDS
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Comment: VISUAL INSPECTION OF GROUND WELDS

10.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

11.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

12.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE COVER PLATE

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Part Number: PB674300169

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PG

PURCHASING



Comment: PURCHASING

SEND TO TALMAR FOR FOAM AND FABRIC

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

16.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-11

Description: 90° COVER PLATE		Work Order: 41511
Inspection Dwg: PB 6743001-69		Part Number: PB 6743001-69
Rev: B1		Page 1 of 1

Part Number:	PB 674 3001-69
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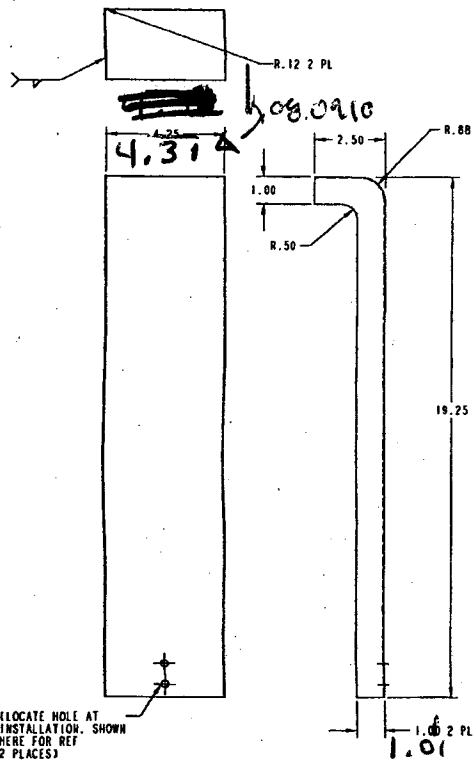
Page 1 of 1

☒ First Article ☒ Prototype

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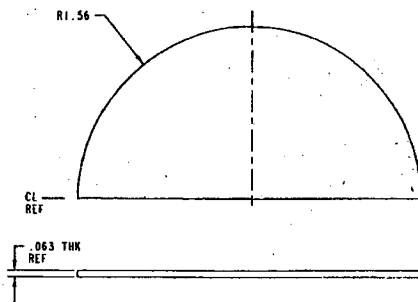
Rev	Date	Change	Date:	17
A		New Issue	Revised by	Approved
			KJ/JLM	

RELEASED

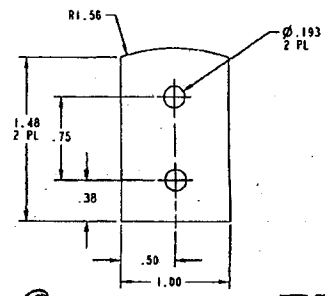


-69 90 DEGREE COVER PLATE

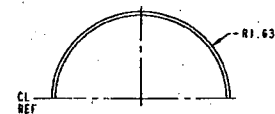
MATL: .032 THK, 6061-T6, 00-A-250/11
SCALE 0.500



⑧ -339 D-PAD TOP
MATL: .063 THK, 6061-T6, 00-A-250/11
SCALE 2.000

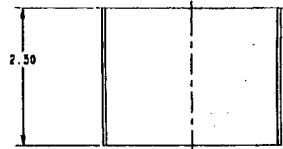


⑧ -193 D-PAD BASE
MATL: .125 THK, 6061-T6, 00-A-250/11
SCALE 2.000



⑥ -185 D-PAD BACK PLATE

MATL: .063 THK, 6061-T6, 00-A-250/11
SCALE 1.000



⑥ -189 D-PAD FACE
MATL: .063 THK, 6061-T6, 00-A-250/11
SCALE 1.000

PREMIER AVIATION, INC.
2800 Aviation Parkway, Grand Prairie, Texas 75052
D10SUV8 B67-43001
REV. 81
SCALE: 25 = 1

ORIGINAL

NO 4151
WORK ORDER
SUBJECT TO AGREEMENT
UNCONTROLLED COPY
RETURN TO
ENGINEERING
WITHOUT NOTICE